

Work Order ID 148320

Tuesday, June 28, 2016 9:04:01 AM

148320

Page 1

Item ID: D2521

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Individual Bearpaw

Start Date: 6/13/2016 Start Qty: 6.00 ~~8.0~~ ***6*** 8.0

Cust Item ID:

Required Date: 6/27/2016 Req'd Qty: 6.00 ~~6.00~~ ***6***

Customer:

Reference:

DAS

Approvals:

Process Plan: 21

Date: JUL 05 2016 Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2521	Rev J								

120

0.00

120

FLOW WATER JET

Waterjet

Memo

0.46

FLOW CNC Waterjet

Cut Blank as per D2521 blank file

8 16/07/13

130

0.04

130

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.84

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining
2-Machine as per Folio and Dwg D2521 Identify as D2521
3-Deburr

8 16-07-21

140

0.00

140

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.01

Quality Control

8 16-07-21

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐						
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval				
Description Work Order Deviation			Disposition					
						Completed By		
						Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval					
Root Cause		FAULT CATEGORY						
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER :								

Tuesday, June 28, 2016 9:04:01 AM

148320

Page 2

N900040100

Setup **Start** ***NS1***

Stop *NS2*

Start Date: 6/13/2016 **Start Qty:** 6.00

6

Cust Item ID:

Required Date: 6/27/2016 **Req'd Qty:** 6.00

6

Customer:

Reference:

Run Start *NR1*

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

[illegible]

DAS
21
9-89

JUL 26 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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		OTHER :																							

Picklist Print

Tuesday, June 28, 2016 9:04:01 AM

Page 1

Work Order ID: 148320

148320

Parent Item: D2521

D2521

Parent Item Name: Individual Bearpaw

Start Date: 6/13/2016

Required Date: 6/27/2016

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 08-10-01 New Manufacturing Method JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased		No			sf	623.3580		44.21053			

MUHMWB10

UHMW 1" Black - 48"x120" Tivar Mfg.#52480104

06/16/07/13

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT	16.9	
m134171	16.9	
MAT018	606.458	
m131661	1.473	
m134372	27.485	
m134823	177.5	
m135013	400	

40
15 + 6

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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DART AEROSPACE LTD		Work Order: 148320
Description: Bearpaw		Part Number: D2521
Inspection Dwg: D2521	Rev: J	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension			Actual Dimension	Accept	Reject	Method of Inspection	Comments
Dim	Min	Max					
A	0.260	0.266	.260	/		Vern	FK-04
B	0.90	0.96	.930	/		"	"
C	0.27	0.330	.298	/		"	"
D	0.470	0.530	.500	/		"	"
E	21.740	21.760	21.750	/		Tape	FK-05
F	0.72	0.780	.747	/		Vern	FK-04
G	0.35	0.410	.380	/		"	"
H	11.490	11.570	11.500	/		Tape	FK-05
I	3.41	3.47	3.429	/		Vern	FK-04
J	11.790	11.810	11.800	/		Tape	FK-05
K	9.47	9.53	9.500	/		Vern	CNC-02
L	7.190	7.210	7.200	/		"	"
M	6.910	6.970	6.940	/		"	"
N	44.47	44.530	44.50	/		Tape	FK-05
O	6.590	6.650	6.627	/		Vern	FK-08
P	0.940	0.980	.956	/		"	"
Q	18.97	19.03	19.000	/		Tape	FK-05
R	0.350	0.410	.380	/		Vern	FK-04
S	0.740	0.780	.757	/		"	"
T	0.240	0.280	.256	/		"	"
U	0.370	0.410	.386	/		"	"
V	0.740	0.780	.760	/		"	"
W	0.740	0.780	.762	/		"	"

DAS

Measured by: 44 9-89	Audited by: R.A. DAS 09	Prototype Approval: N/A
Date: 16-07-21	Date: 16/07/2009	Date: N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D205-564-011 & D430-688-011	KJ/RF	
B	05.06.15	Dimensions and tolerances changed	KJ/RF	
C	06.08.31	Dimensions updated per D2521 Rev. J	KJ/JLM	



DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED #	DRAWING NO. D2521	REV. J SHEET 1 OF 3
DATE 06.07.28		TITLE 205 BEARPAW SCALE NTS	
A	95.11.28	NEW ISSUE	
B	96.01.11	SHOW BENDING MOVE HOLES	
C	96.01.29	ADJUST HOLE LOCATION FOR TOOLING	
D	96.05.14	ADJUSTED BEAR PAW THICKNESS	
E	96.12.18	43.500 WAS 46.750	
F	97.05.07	ADDED REAR POCKET, MOVED HOLES	
G	98.08.06	ADD C'BORE AND CHAMFER EDGES	
H	03.01.30	CHANGE GEOMETRY FOR RUN-ON LDG.	
I	05.05.20	REMOVE BEND; CHANGE TOLERANCES	
J	06.07.28	CHANGE FOR FLOAT SKIDTUBE	

TOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
148320 M25
16-07-05

RELEASED

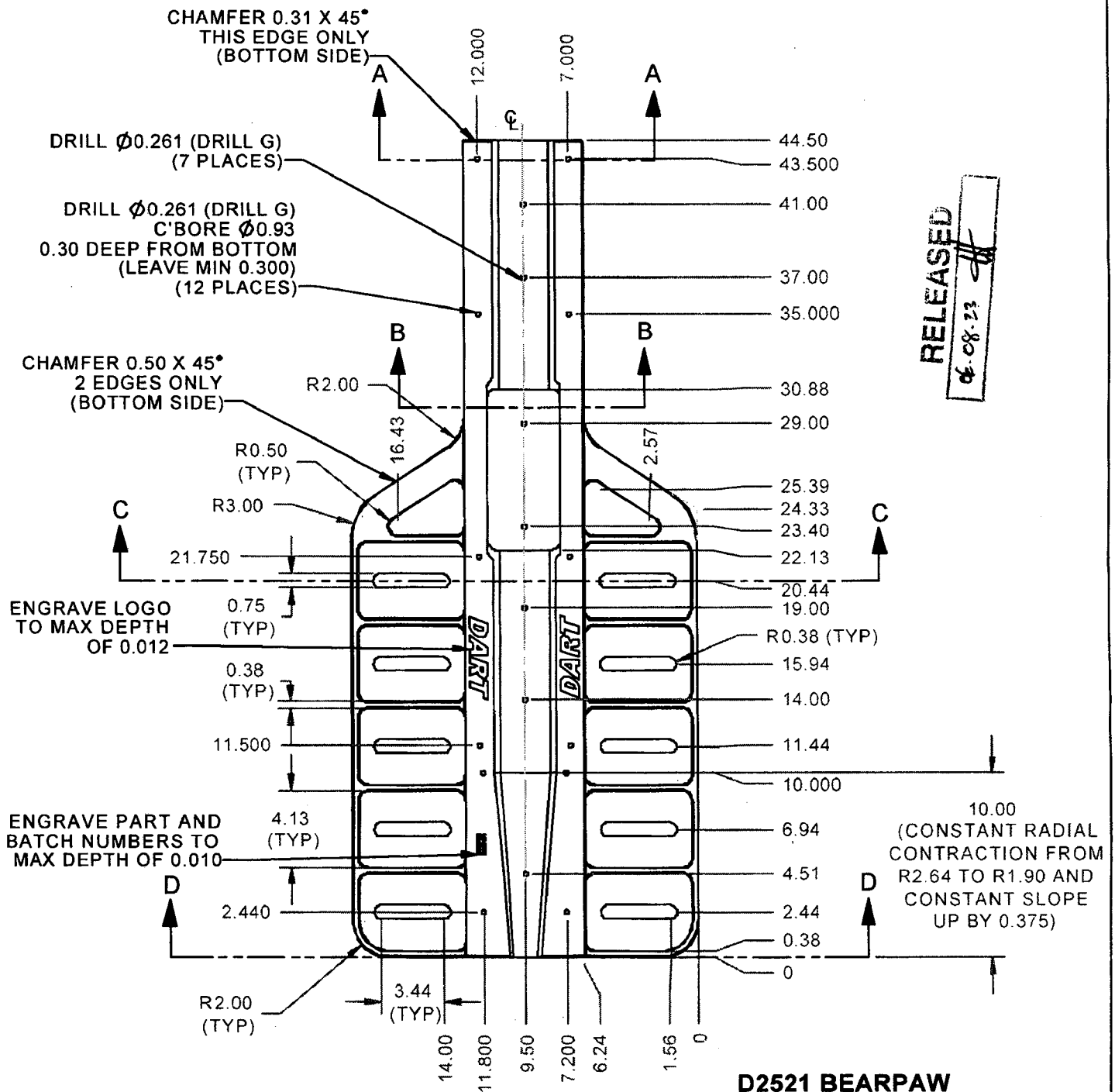
06 08 23 #

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DART

DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED [Signature]	DRAWING NO. D2521	REV. J SHEET 2 OF 3
DATE 06.07.28	TITLE 205 BEARPAW	SCALE 1:8	

RELEASED
06.08.23**NOTES:**

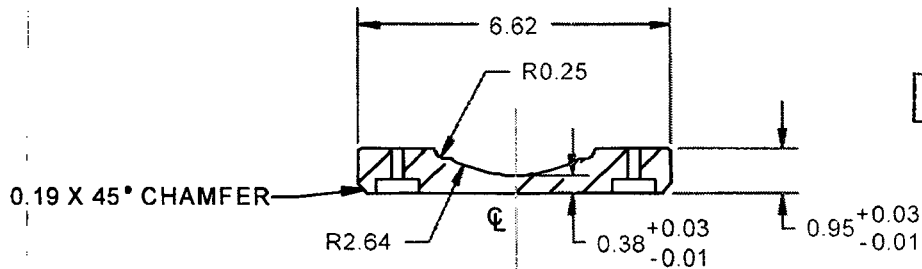
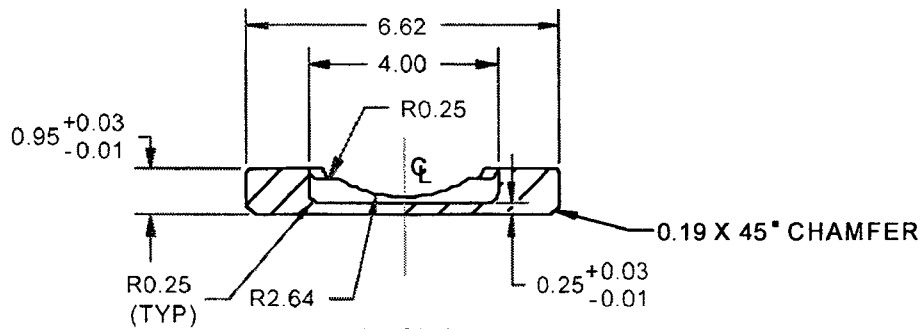
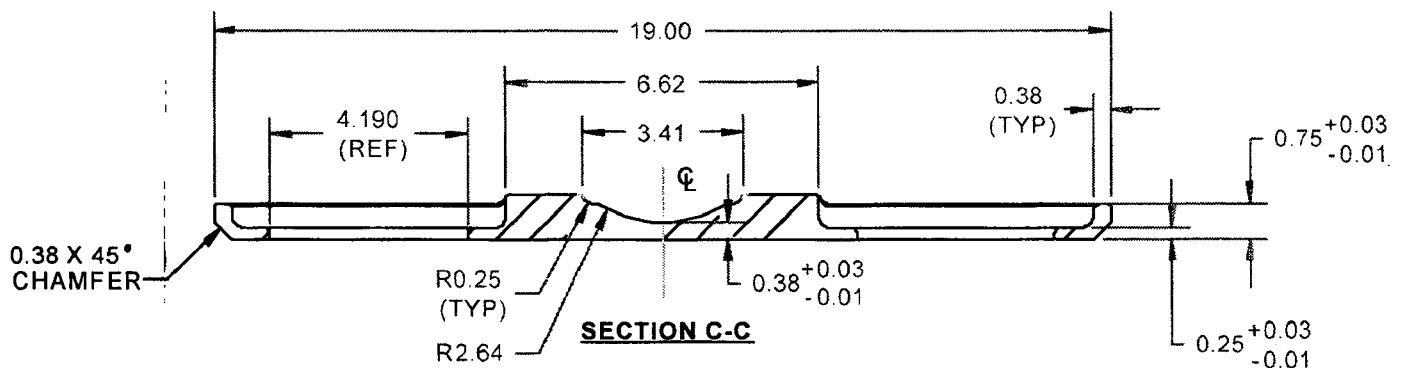
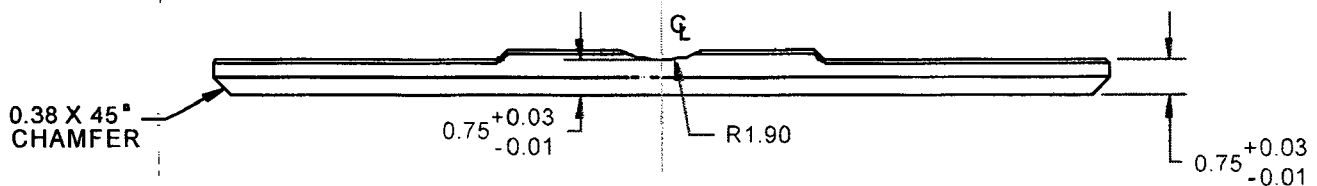
- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.000 THICK (MACHINE TO 0.950)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.030
- 6) PART IS SYMMETRIC ABOUT ϕ

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DART

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CHECKED #	APPROVED #	DRAWING NO. D2521	REV. J SHEET 3 OF 3
DATE 06.07.28	TITLE 205 BEARPAW	SCALE 1:4	

**SECTION A-A****SECTION B-B****SECTION C-C****SECTION D-D****RELEASED**

06.08.23 #

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